

# Work Order ID 57225

March 30, 2010 10:49:47 AM



Page 1

Item ID: D3573-8

Revision ID:

Item Name: Adapter

Start Date: 30/03/2010 Start Qty: 10.00

Required Date: 08/04/2010 Req'd Qty: 10.00

Reference:

*Handwritten: 10-03-30*

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description                 | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr                       | Revision Nbr                             |                      |                |              |              |               |               |                  |                |
| D3573                          | Rev A                                    |                      |                |              |              |               |               |                  |                |
| 100                            | BAND SAW                                 | 0.00                 |                |              |              |               |               |                  |                |
|                                |  |                      |                |              |              |               |               |                  |                |
| Bandsaw                        | Memo                                     | 0.00                 |                |              |              |               |               |                  |                |
| Jaspas Bandsaw                 | Cut blank 3.500" long                    |                      |                |              |              |               |               |                  |                |
|                                |  |                      |                |              |              |               |               |                  |                |
| 110                            | HAAS CNC VERTICAL MACHINING #1           | 0.00                 |                |              |              |               |               |                  |                |
|                                |  |                      |                |              |              |               |               |                  |                |
| HAAS 1                         | Memo                                     | 0.00                 |                |              |              |               |               |                  |                |
| HAAS CNC vertical machine #1   | Machine as per Folio FA679 and Dwg D3573 |                      |                |              |              |               |               |                  |                |
|                                |  |                      |                |              |              |               |               |                  |                |
| 120                            | QC2- Inspect parts off machine FAI/FAIB  | 0.00                 |                |              |              |               |               |                  |                |
|                                |  |                      |                |              |              |               |               |                  |                |
| QC                             | Memo                                     | 0.00                 |                |              |              |               |               |                  |                |
| Quality Control                |  |                      |                |              |              |               |               |                  |                |

*Handwritten: 28 10/03/31*

*Handwritten: 10*

*Handwritten: 28 10/03/31*

*Handwritten: 10*

*Handwritten: 28 10/03/31*

*Handwritten: 10*



# Work Order ID 57225

March 30, 2010 10:49:47 AM



Page 2

Item ID: D3573-8

Accept



Setup Start



Revision ID:

Item Name: Adapter

Stop



Start Date: 30/03/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 08/04/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

SL 10/03/31



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

BR 10-4-1

Ⓟ



HandFinish

Memo

0.00

Hand Finishing

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

11/112588

SL 10/04/09

X10



Powdercoat

Memo

0.00

Powder Coating

START TIME: 1:45pm  
OVEN TEMPERATURE: 320°  
FINISH TIME: 2:15pm





# Work Order ID 57225

March 30, 2010 10:49:47 AM



Page 3

Item ID: D3573-8

Revision ID:

Item Name: Adapter

Start Date: 30/03/2010 Start Qty: 10.00

Required Date: 08/04/2010 Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

BR 10-4-8

10, 10

170



Packaging

Packaging

Identify as per dwg & Stock Location: 247

0.00

Memo

0.00

10/4/9 10

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/12

mf  
10-4-9



# Picklist Print

March 30, 2010 10:49:46 AM

Page 1

Work Order ID: 57225

Parent Item: D3573-8

Parent Item Name: Adapter

Comments: IPP Rev:A New Issue 07-01-29 JLM

Start Date: 30/03/2010

Required Date: 08/04/2010

Start Qty: 10.00

Required Qty: 10.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M6061T6B0.500X02.50<br>0        |                        | Purchased     | No          |                     |                  | 100             | f                  | 27.5923        | 3.0737                   |               |                |        |



6061-T6 Bar .500 x 2.50



| <u>Warehouse</u><br><u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-------------------------------------|----------------|-----------------|
| Main Warehouse                      |                |                 |
| MAT02                               | 27.59231579    |                 |
| 103435                              | 1.06           |                 |
| 104366                              | 26.5323158     |                 |

3.0737 818 10/03/31





|                       |        |              |         |
|-----------------------|--------|--------------|---------|
| DART AEROSPACE LTD    |        | Work Order:  |         |
| Description: Adapter  |        | Part Number: | D3573-8 |
| Inspection Dwg: D3573 | Rev: A | Page 1 of 1  |         |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance       | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------------|------------------|--------|--------|----------------------|----------|
| 3.32              | +/-0.030        | 3.312            | ✓      |        |                      |          |
| 2.75              | +/-0.030        | 2.754            | ✓      |        |                      |          |
| 0.36              | +/-0.030        | .354             | ✓      |        |                      |          |
| 1.600             | +/-0.010        | 1.600            | ✓      |        |                      |          |
| 0.48              | +/-0.030        | .475             | ✓      |        |                      |          |
| 2.38              | +/-0.030        | 2.374            | ✓      |        |                      |          |
| 1.420             | +/-0.010        | 1.417            | ✓      |        |                      |          |
| 1.813             | +/-0.010        | 1.814            | ✓      |        |                      |          |
| Ø0.209            | +0.005/-0.001   | .210             | ✓      |        |                      |          |
| Ø0.201            | +0.005/-0.001   | .203             | ✓      |        |                      |          |
| Ø0.90 x 0.100     | +/-0.010        | .900             | ✓      |        |                      |          |
| Ø0.500 x 0.310    | +/-0.010        | .497             | ✓      |        |                      |          |
| 0.390             | +/-0.010        | .388             | ✓      |        |                      |          |
| Ø0.385 x 100°     | +/-0.010 x 0.5° | .380 x 100°      | ✓      |        |                      |          |
| R0.63             | +/-0.030        | .630             | ✓      |        |                      |          |
| R0.13             | +/-0.030        | .130             | ✓      |        |                      |          |
| R0.02             | +/-0.030        | 0.0              | ✓      |        |                      |          |
|                   |                 |                  |        |        |                      |          |
|                   |                 |                  |        |        |                      |          |
|                   |                 |                  |        |        |                      |          |
|                   |                 |                  |        |        |                      |          |
|                   |                 |                  |        |        |                      |          |
|                   |                 |                  |        |        |                      |          |

|                        |                       |                     |     |
|------------------------|-----------------------|---------------------|-----|
| Measured by: <i>SL</i> | Audited by: <i>SL</i> | Prototype Approval: | N/A |
| Date: 10/03/31         | Date: 10/03/31        | Date:               | N/A |

| Rev | Date     | Change    | Revised by       | Approved  |
|-----|----------|-----------|------------------|-----------|
| A   | 07.06.13 | New Issue | KJ/JLM <i>SL</i> | <i>SL</i> |

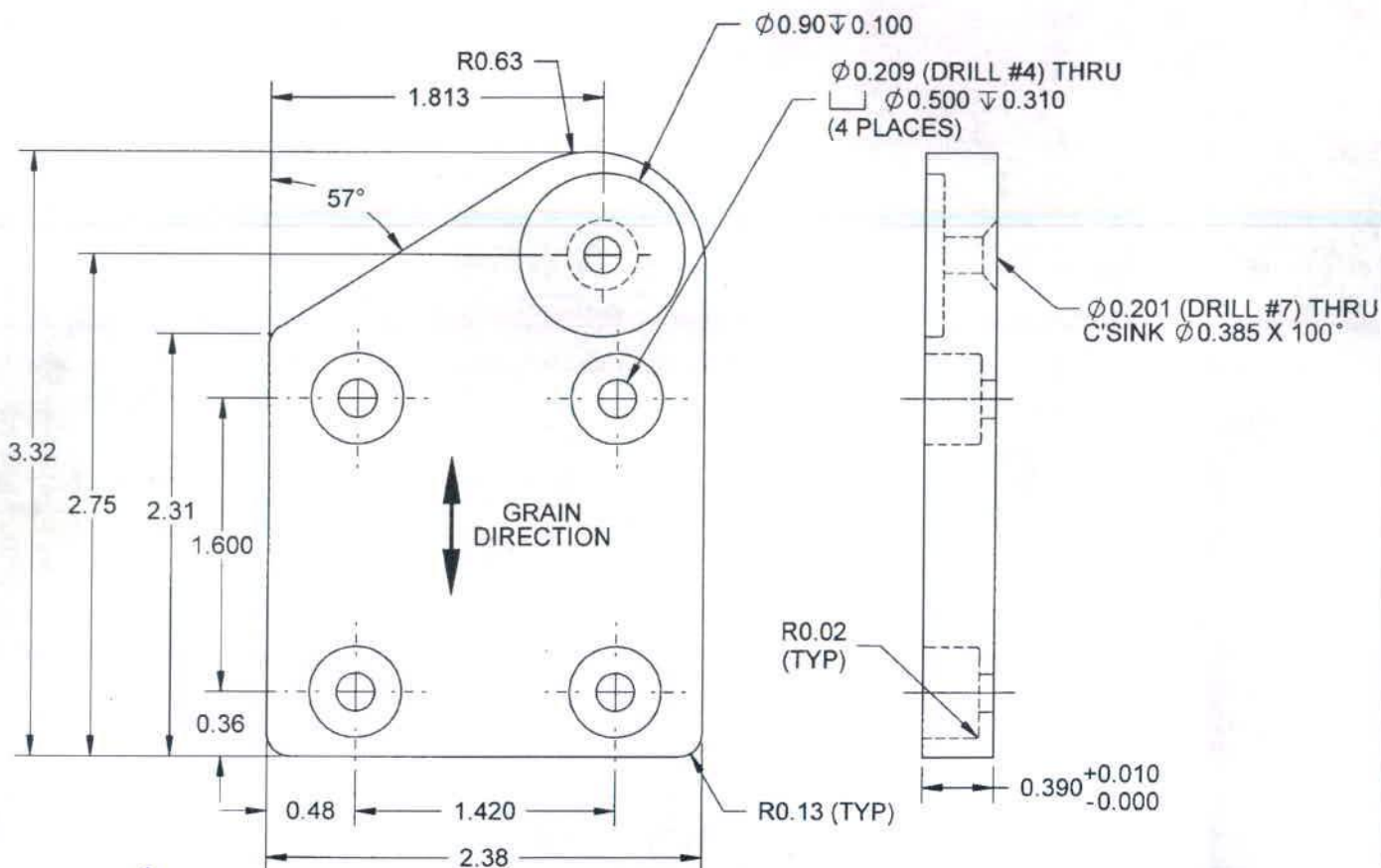






|                      |                                |   |                              |
|----------------------|--------------------------------|---|------------------------------|
| DESIGN<br><i>LE</i>  | DRAWN BY<br><i>LE</i>          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                              |
| CHECKED<br><i>PH</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3573                              | REV. A                       |
| DATE<br>07.02.19     | TITLE<br>ADAPTER               |   | SHEET 4 OF 4<br>SCALE<br>1:1 |

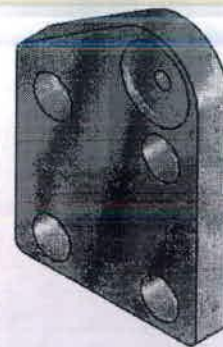
RELEASED  
07.04.02



**D3573-7 ADAPTER (SHOWN)**  
**D3573-8 ADAPTER (OPPOSITE)**

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR  
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160  
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-7/-8" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

